












Date: Friday, 24/10/2008 3:29:47 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HOUSING
Job Number	: 42939		
Estimate Number	: 11870		
P.O. Number	:	Part Number	: D22071
This Issue	: 24/10/2008	S.O. No.	: <i>Small/fab</i>
Prsht Rev.	: NC	Drawing Number	: D2207 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 35094	Drawing Revision	: C
Written By	:	Material	:
Checked & Approved By	: <i>JW 08.10.24</i>	Due Date	: 05/11/2008
Comment	: Est. A 01.03.08 New Issue	Qty:	10 Um: Each
	Est rev B 07.09.11 ecn 998 EC verified by: JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S063	6061-T6 .063 Sheet	
			
Comment: Qty.: 0.4375 sf(s)/Unit Total: 4.3754 sf(s) 6061-T6 .063 Sheet 5052-H32 or 6061-T6 - .063" Thick Batch <i>108279</i> <i>HB 8-11-10</i>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2207 Dwg Rev: <i>C</i> <i>HB 8-11-10</i> Prog Rev: <i>C</i> 2-Deburr if necessary <i>HB 8-11-10</i>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>HB 8-11-10</i>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>08.11.11</i>			
5.0	BENDING	BENDING MACHINE - SKIDTUBES	
			
Comment: BENDING MACHINE Bend as per dwg D2207 <i>SB 09/02/25</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
7							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 1 Friday, 24/10/2008 3:29:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 42939

Part Number: D22071

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/25 (+10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WELDING

BE 09/03/03

(11)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/03

Job Completion



mf
09-03-03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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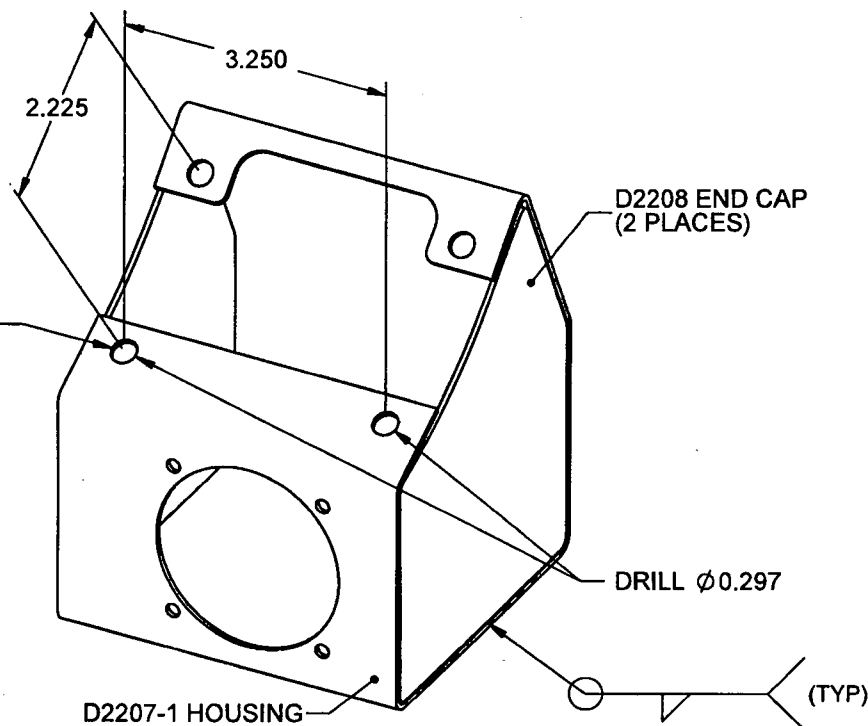
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NOTE: Date & initial all entries

AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)



RELEASED

07.08.29

D2207-041 HOUSING ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 100191

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>PH</i>	DRAWING NO. D2207	
MFG. APPR.	<i>EE</i>	REV. C SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE HOUSING	
DE APPR.	<i>[Signature]</i>	SCALE 1:2	
DATE	07.06.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

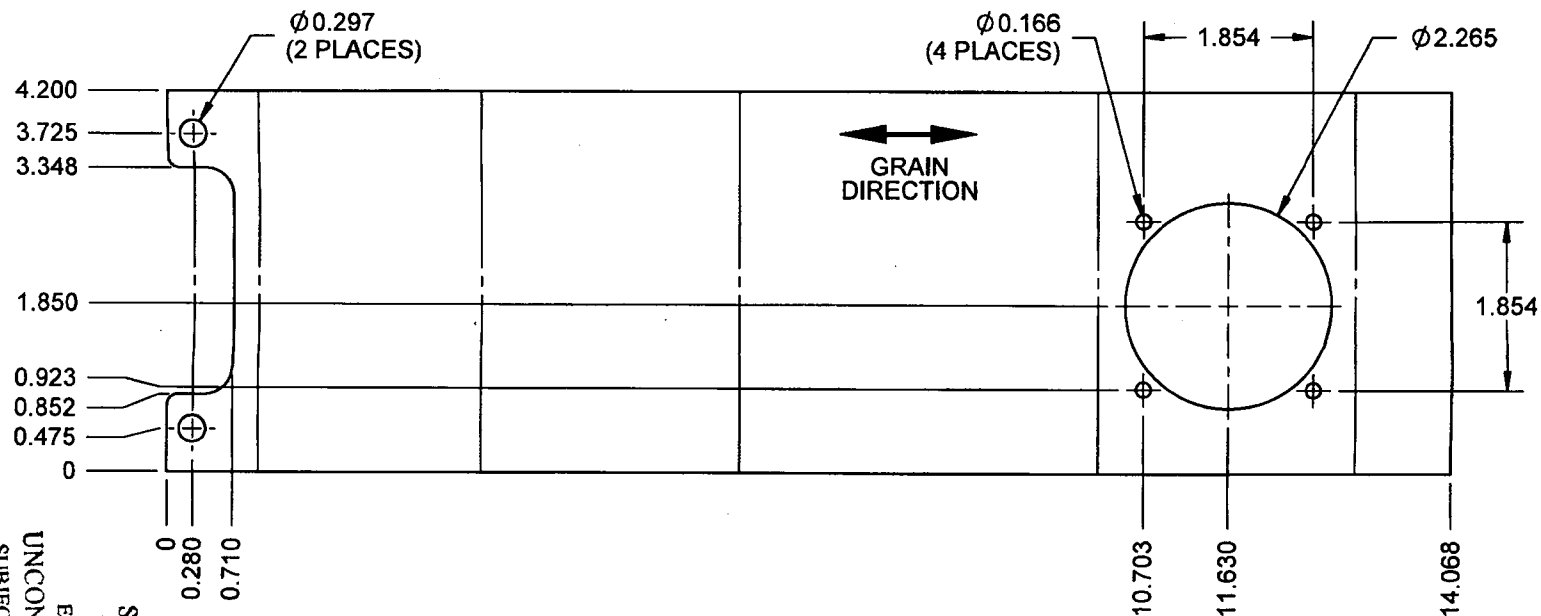
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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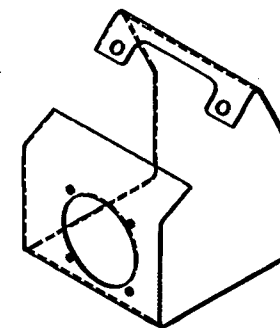
NOTE: Date & initial all entries



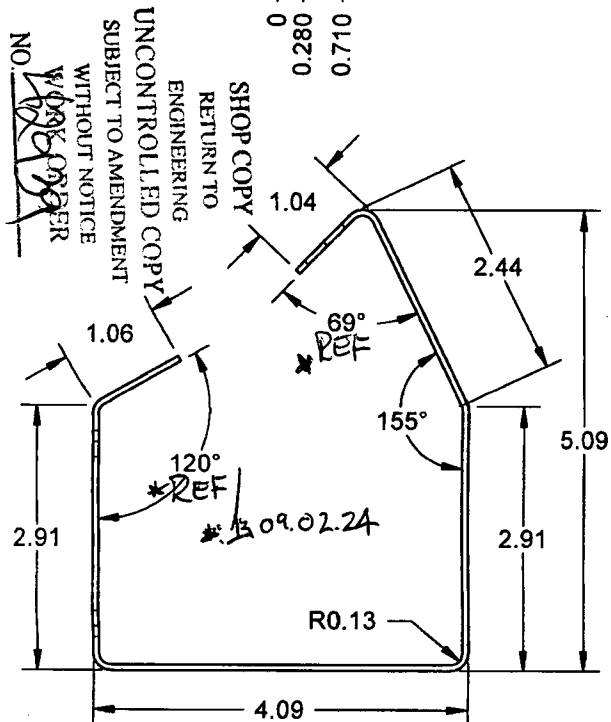
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D2207	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HOUSING	1:2
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